



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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009637

D4149-041
Job Sheet 192880



Part No: D4149-041

Job Qty: 5 pcs

Part Name: Aft Crosstube Lug Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/3/19

Job Tracking No:

Due Date: 4/19/19

Created By: Shannon Hadley

Type: Stock

Description:

Note: DWG REV C IPP Rev:A 10.06.24 new issue DD verf:EC IPP Rev:B 10.07.22 as per revB DD verf:JLM IPP
Rev:C 11.03.03 as per revC DD verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		DAS Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	5 pcs	4/19/19		0.00	1.25	Small Fab - 1		58 9-89 MAY 07 2019
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	5 pcs	4/19/19		0.00	0.00	QC 5 - 10		DAS 40 MAY 08 2019 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
120	Packaging 3-1 - Stock - B4B	5 pcs	4/19/19		0.00	0.00	Packaging 3 - 1 - B4B		DAS 40 MAY 09 2019 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B	5753900	
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		

					Packaging 3 - 7 - B4B					
					Packaging 3 - 8 - B4B					
					Packaging 3 - 9 - B4B					
					Packaging 3 - 10 - B4B					
					Packaging 3 - 11 - B4B					
					Packaging 3 - 12 - B4B					
					Packaging 3 - 13 - B4B					
					Packaging 3 - 14 - B4B					
					Packaging 3 - 15 - B4B					
					Packaging 3 - 16 - B4B					
					Packaging 3 - 17 - B4B					
					Packaging 3 - 18 - B4B					
					Packaging 3 - 19 - B4B					
					Packaging 3 - 20 - B4B					
					Packaging 3 - 21 - B4B					
					Packaging 3 - 22 - B4B					
					Packaging 3 - 23 - B4B					
					Packaging 3 - 24 - B4B					
					Packaging 3 - 25 - B4B					
					Packaging 3 - 26 - B4B					
					Packaging 3 - 27 - B4B					
					Packaging 3 - 28 - B4B					
					Packaging 3 - 29 - B4B					
					Packaging 3 - 30 - B4B					
					Packaging 3 - 31 - B4B					
					Packaging 3 - 32 - B4B					
					Packaging 3 - 33 - B4B					
					Packaging 3 - 34 - B4B					
					Packaging 3 - 35 - B4B					
					Packaging 3 - 36 - B4B					
					130 QC 21 - SA	5 pcs	4/19/19	0.00 0.00	QC 21 - SA - 21	DAS
									QC 21 - SA - 70	21
									QC 21 - SA - 53	9-69 MAY 09 2019

Part Op 110 - (QC5- Inspect part completeness to step on W/O)
 Descriptions: 120 - (Identify as per dwg & Stock Location: _____)
 130 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3C12A	Bolt	10 Ea (2 ea)	100-Small Fab - 1	3149192
AN4C13A	Bolt	15 Ea (3 ea)	100-Small Fab - 1	3157509
ST525 D3910-1	Crosstube Lug	5 pcs (1 ea)	100-Small Fab - 1	3174260
ST525 D4091-1	Mounting Lug	5 pcs (1 ea)	100-Small Fab - 1	3174252
ST050 D4149-1	Crosstube Lug Plate, Aft	10 pcs (2 ea)	100-Small Fab - 1	3158315
ST081 D4149-3	Spacer	5 pcs (1 ea)	100-Small Fab - 1	3176718
ST081 D4149-5	Eyebolt Stud	5 pcs (1 ea)	100-Small Fab - 1	3152228
ST306 MS20615-4M18	Rivet	15 Ea (3 ea)	100-Small Fab - 1	3160340
ST302 MS21043-3	Nut	10 Ea (2 ea)	100-Small Fab - 1	3149144
ST302 MS21043-4	Nut	15 Ea (3 ea)	100-Small Fab - 1	3173785
ST266 NAS1149C0332R	Washer	20 Ea (4 ea)	100-Small Fab - 1	3174158
ST266 NAS1149C0432R	Washer	30 Ea (6 ea)	100-Small Fab - 1	3155658

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	AN3C12A	10	201	0
	AN4C13A	15	204	0
	D3910-1	5	22	0
	D4091-1	5	15	0
	D4149-1	10	13	0
	D4149-3	5	20	0
	D4149-5	5	12	0
	MS20615-4M18	15	335	0
	MS21043-3	10	1,156	0
	MS21043-4	15	1,021	0
	NAS1149C0332R	20	4,415	0
	NAS1149C0432R	30	1,804	0
Part Specifications				
Specifications could not be found.				

Plex 4/3/19 10:46 AM Dart.Hadley.Shannon



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D4149-041
Job Sheet 192866



Part No: D4149-041

Job Qty: 5 ea

Part Name: Aft Crosstube Lug Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/3/19

Job Tracking No:

Due Date: 4/19/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP Rev:A 10.06.24 new issue DD verf:EC IPP Rev:B 10.07.22 as per revB DD verf:JLM IPP Rev:C 11.03.03 as per revC DD verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea	4/19/19	4/19/19	0.00	0.00	Start Up Small Fab-3		
100	Small Fab	5 pcs	4/19/19	4/19/19	0.00	1.25	Small Fab-6		
110	QC	5 pcs	4/19/19	4/19/19	0.00	0.00	QC5		
120	Packaging	5 pcs	4/19/19	4/19/19	0.00	0.00	Packaging3-2		
130	QC21-SA	5 Ea	4/19/19	4/19/19	0.00	0.00	QC21		

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3C12A	Bolt	10 Ea (2 ea)	90-Start up Operation	
AN4C13A	Bolt	15 Ea (3 ea)	90-Start up Operation	
D3910-1	Crosstube Lug	5 pcs (1 ea)	90-Start up Operation	
D4091-1	Mounting Lug	5 pcs (1 ea)	90-Start up Operation	
D4149-1	Crosstube Lug Plate, Aft	10 pcs (2 ea)	90-Start up Operation	
D4149-3	Spacer	5 pcs (1 ea)	90-Start up Operation	
D4149-5	Eyebolt Stud	5 pcs (1 ea)	90-Start up Operation	
MS20615-4M18	Rivet	15 Ea (3 ea)	90-Start up Operation	
MS21043-3	Nut	10 Ea (2 ea)	90-Start up Operation	
MS21043-4	Nut	15 Ea (3 ea)	90-Start up Operation	
NAS1149C0332R	Washer	20 Ea (4 ea)	90-Start up Operation	
NAS1149C0432R	Washer	30 Ea (6 ea)	90-Start up Operation	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3C12A	10	201	0
	AN4C13A	15	204	0
	D3910-1	5	22	0
	D4091-1	5	15	0
	D4149-1	10	13	0
	D4149-3	5	20	0
	D4149-5	5	12	0
	MS20615-4M18	15	335	0
	MS21043-3	10	1,156	0
	MS21043-4	15	1,021	0
	NAS1149C0332R	20	4,415	0
	NAS1149C0432R	30	1,804	0
Part Specifications				
Specifications could not be found.				

Plex 4/3/19 9:27 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042) _____	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

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AEROSPACE

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Container No: S178649



Part: D4149-041

Part No: 192880

Serial No/Batch: S178649

Revision:

Inspector:

SA Date:

Instructions: Various STC's

Date: 05/07/19